

*for*

Form: process

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 9/15/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:14:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 34621

Part Number: D3354043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/27/07/14 (42)

6.0

POWDER COATING

POWDER COATING



M18052



(2X)

Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

m-h 07/09/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 070916



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57491

07/15/17

(2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/18

Job Completion



07/09/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

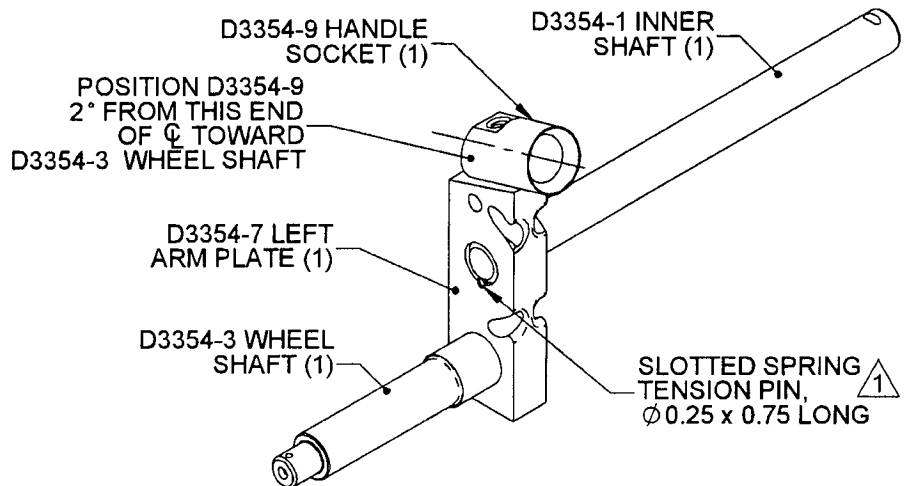
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

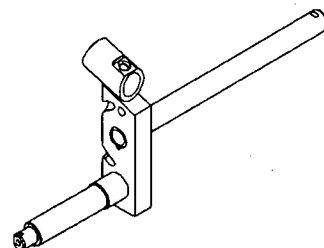


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CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. <b>LEFT ARM WELDMENT</b>	REV. B SHEET 1 OF 7
DATE <b>07.02.02</b>	TITLE <b>D3354</b>		SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

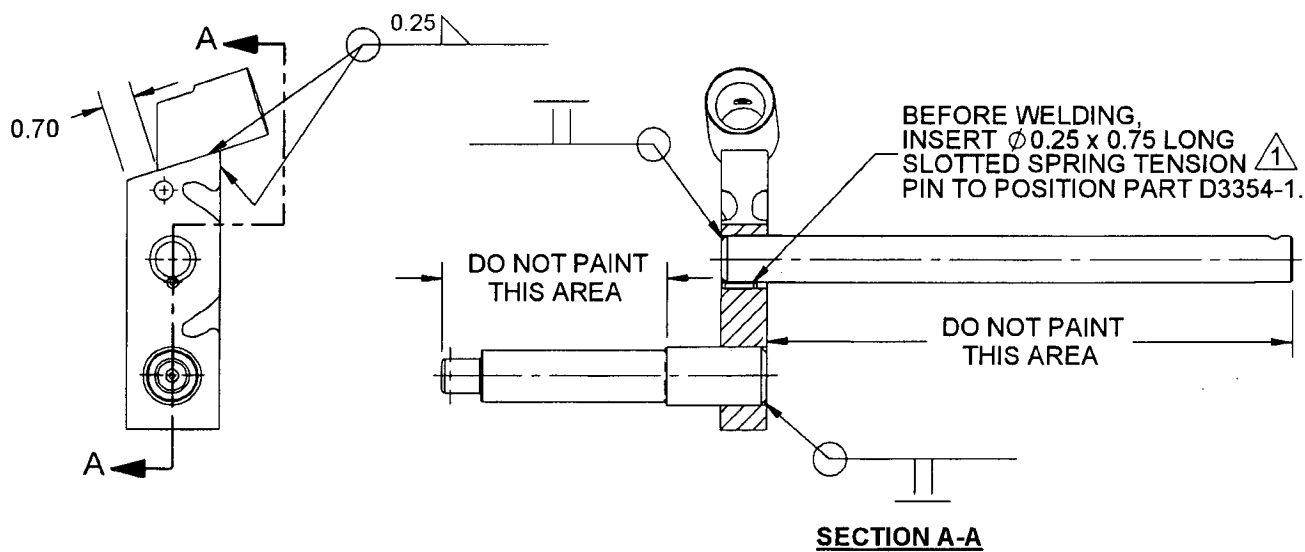
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*RF* 07.02.02



**D3354-041 LEFT ARM WELDMENT**



**D3354-042 MIRROR ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

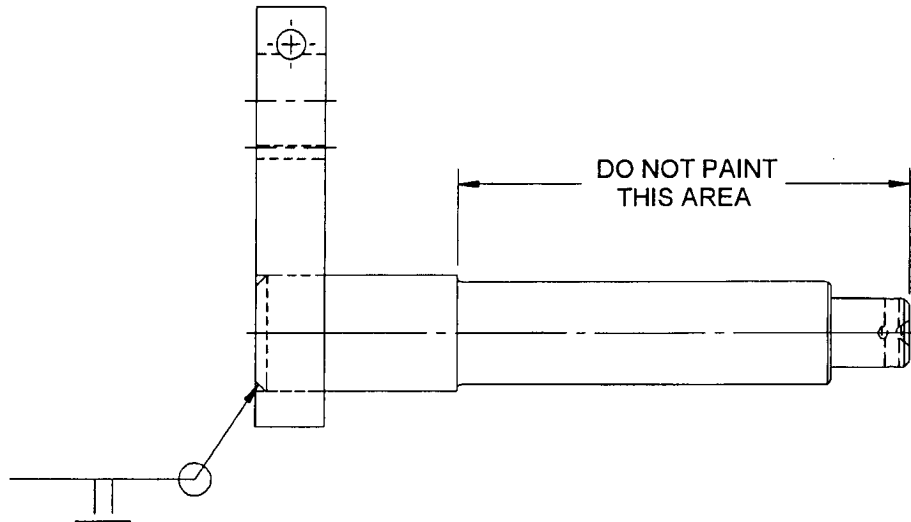
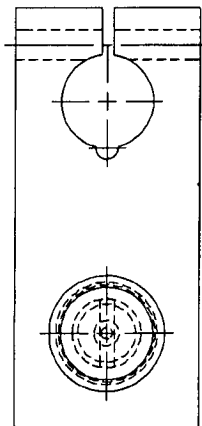
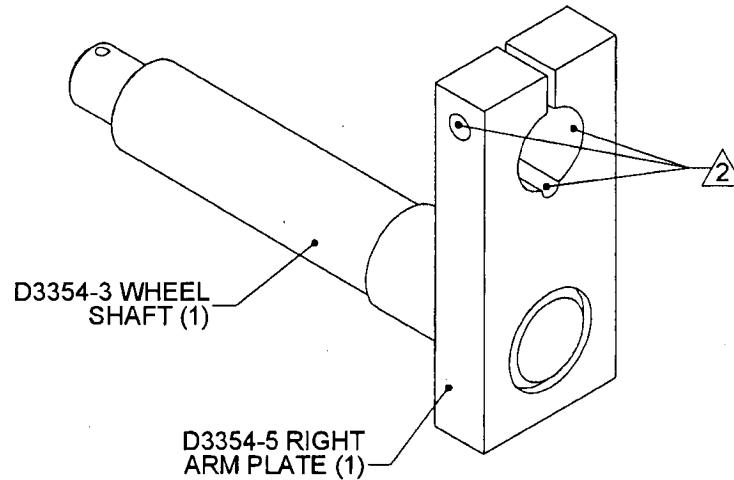
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DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
*[Stamp]* 07.02.02**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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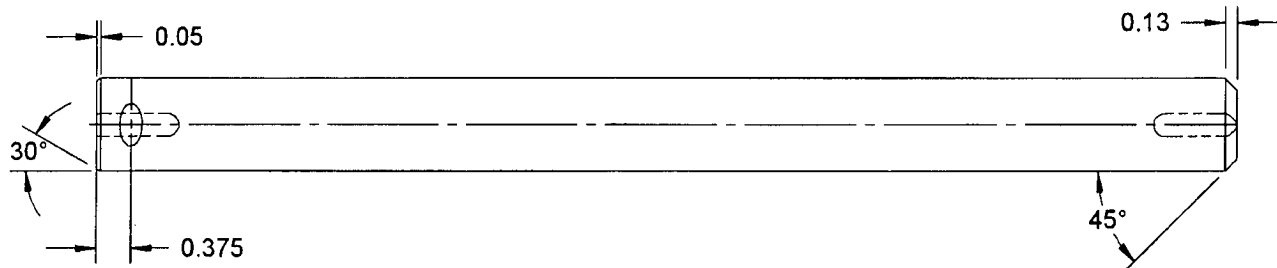
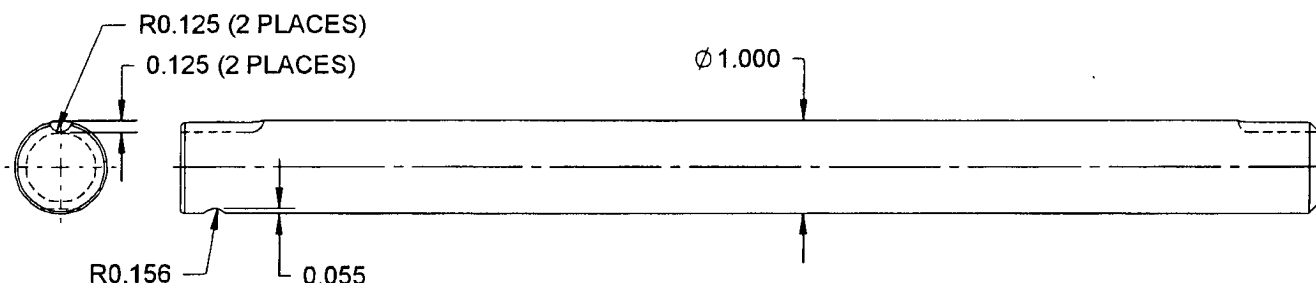
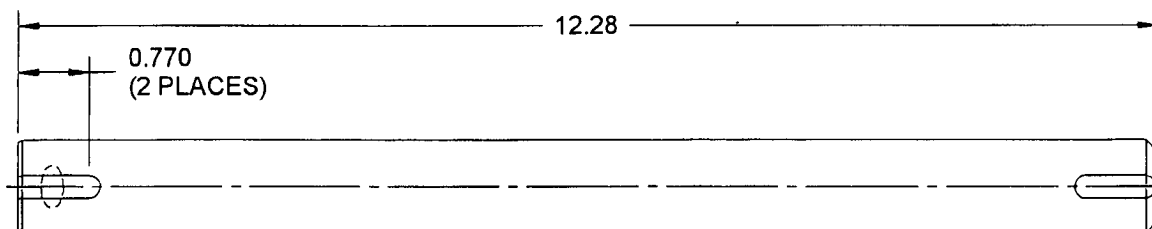
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

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*[Signature]* 07.02.02



### D3354-1 INNER SHAFT

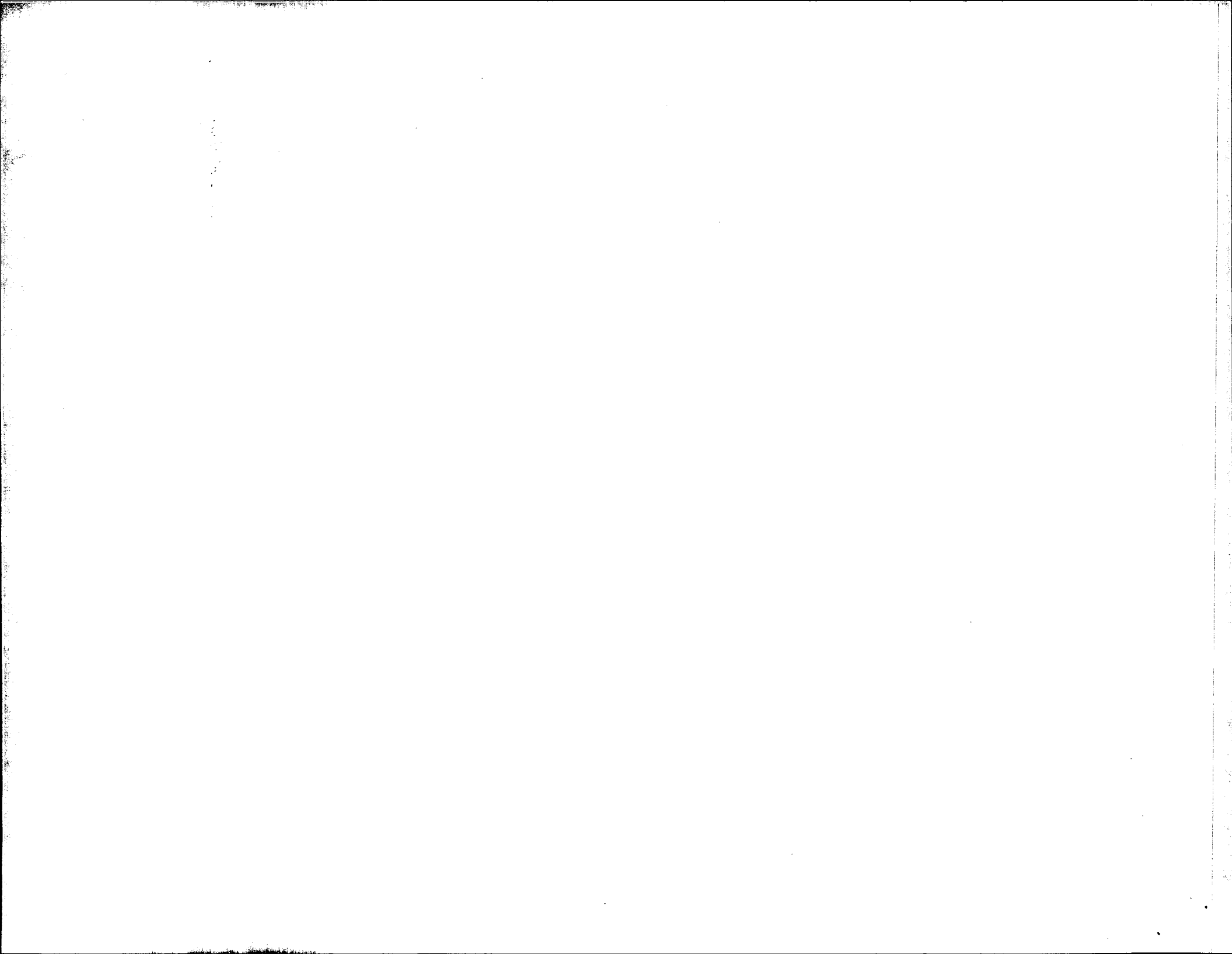
#### NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91  
OR UNS# G41400 ROUND BAR,  $\phi$  1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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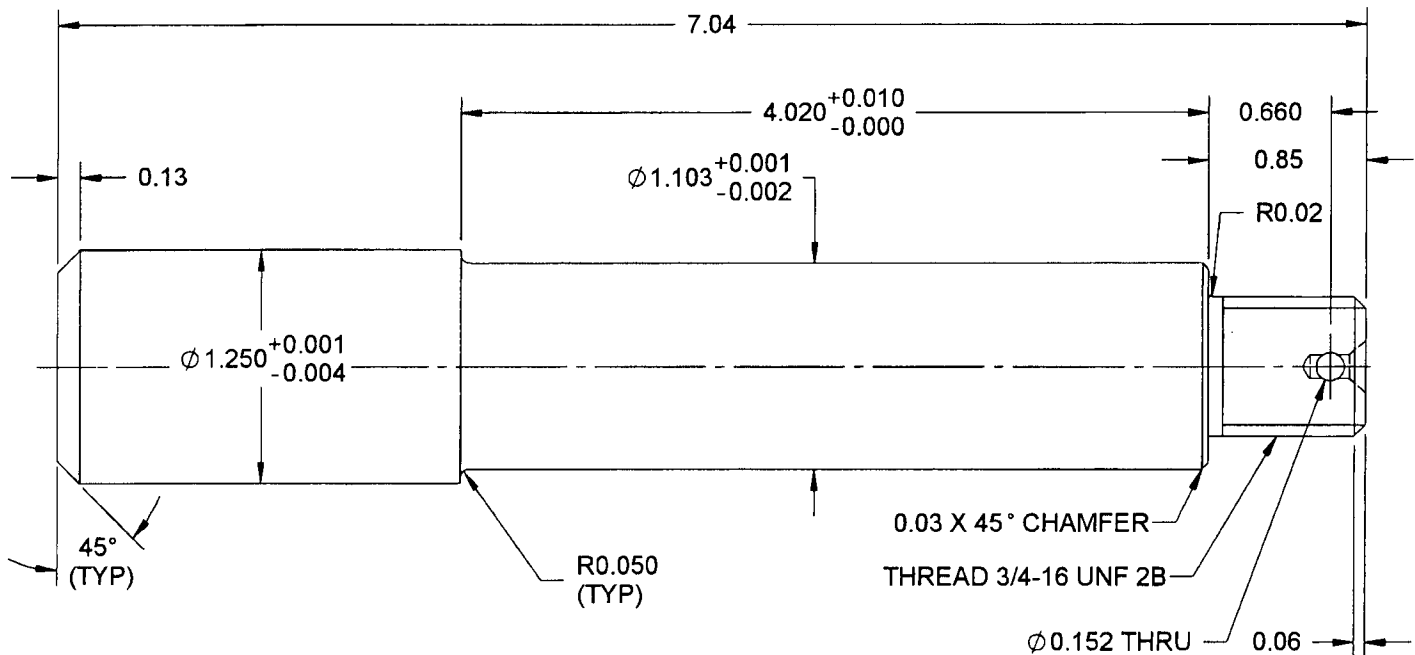
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DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

**RELEASED**  
*[Signature]* 07.02.02**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-01 OR UNS# G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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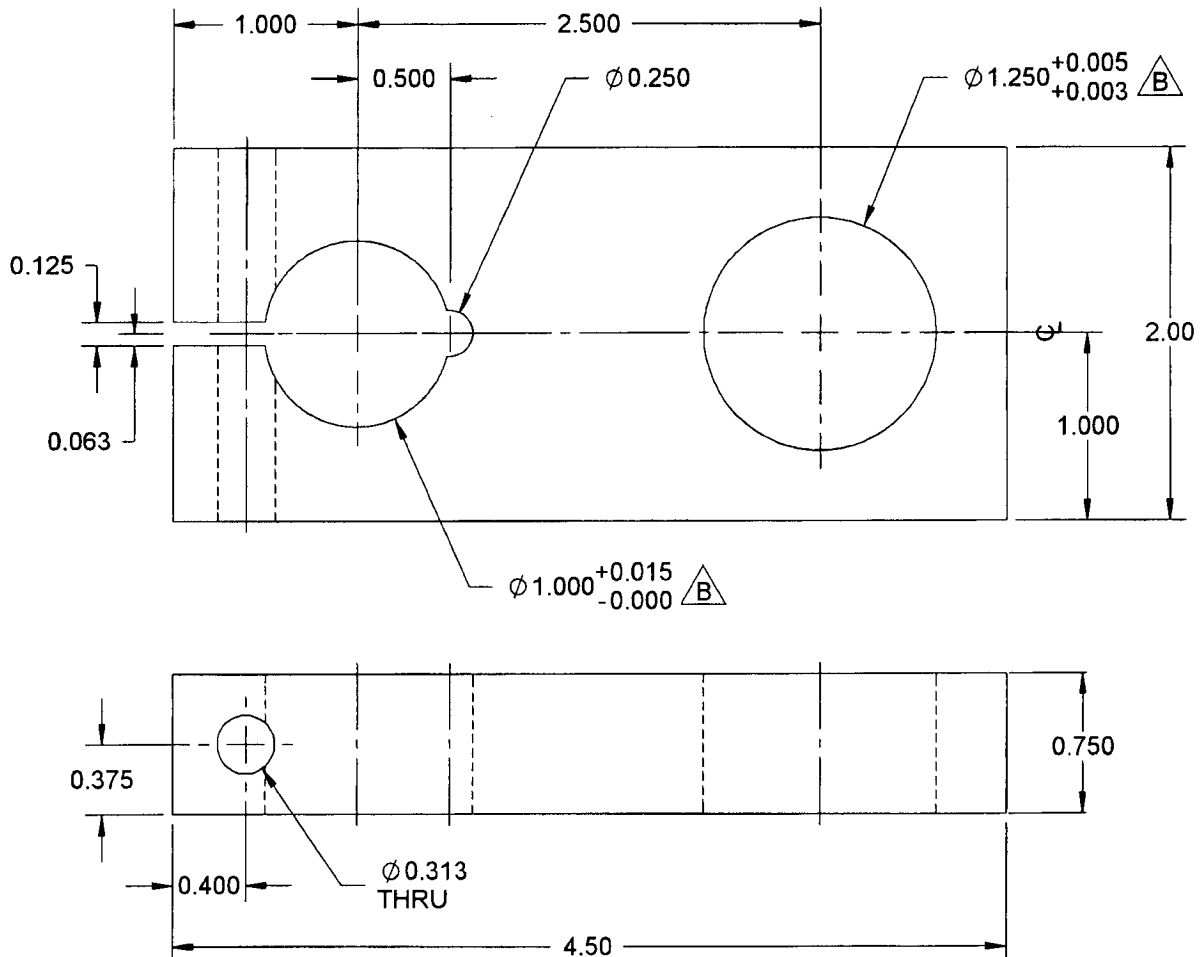
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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

**RELEASED**  
*[Signature]* 07.02.02**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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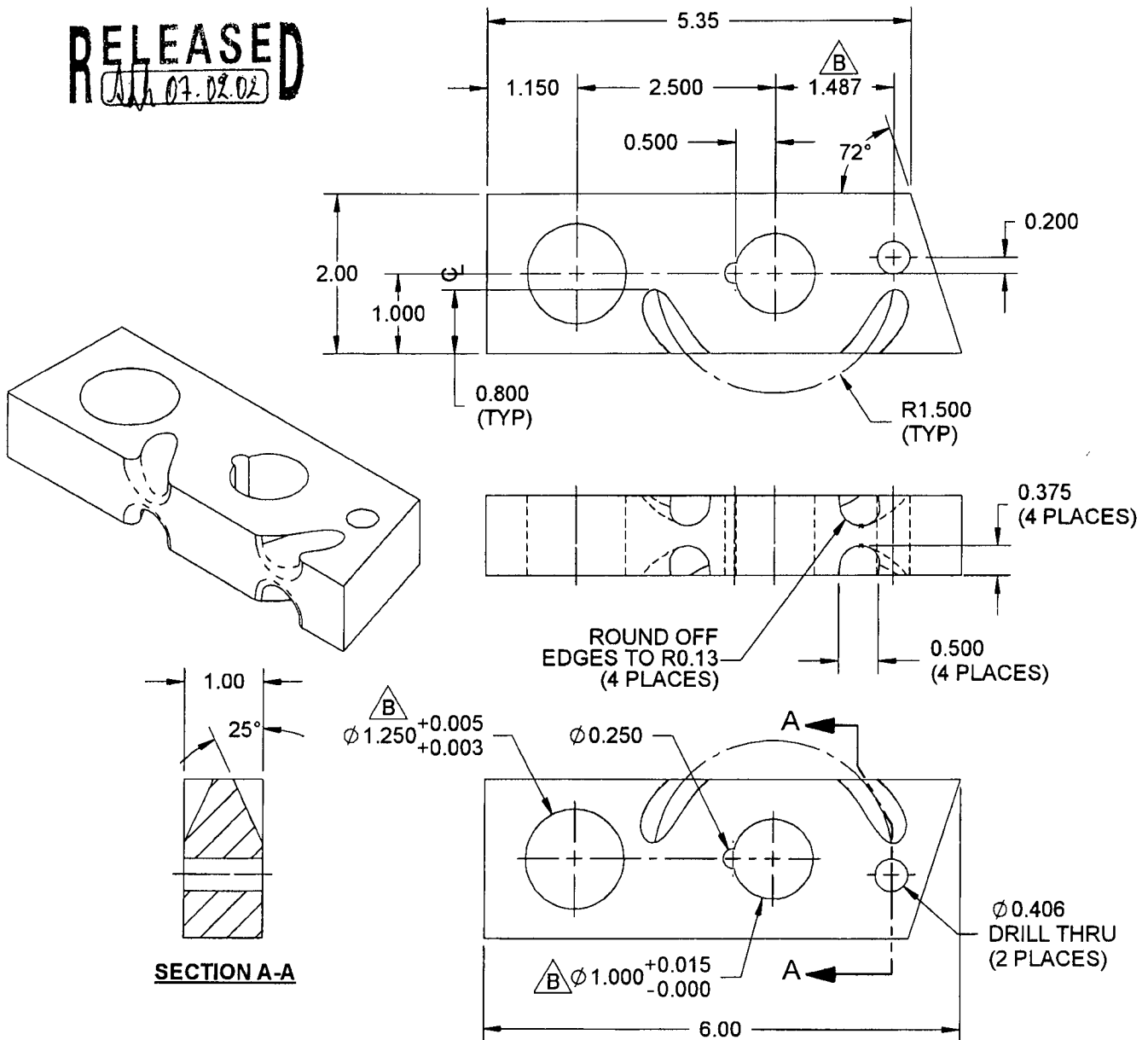
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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b> SCALE 1:2	

RELEASED  
JUN 07.02.02



**D3354-7 LEFT ARM PLATE**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD  
STEEL BAR (REF. DART SPEC. M1010-B)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

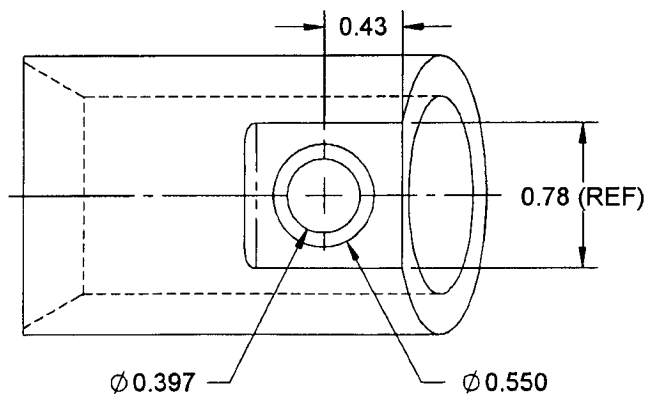
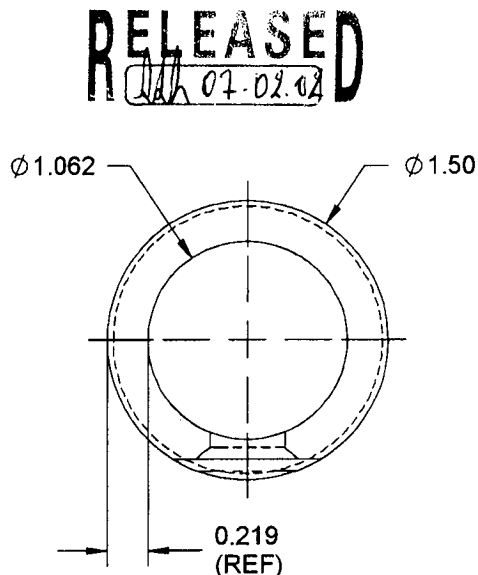
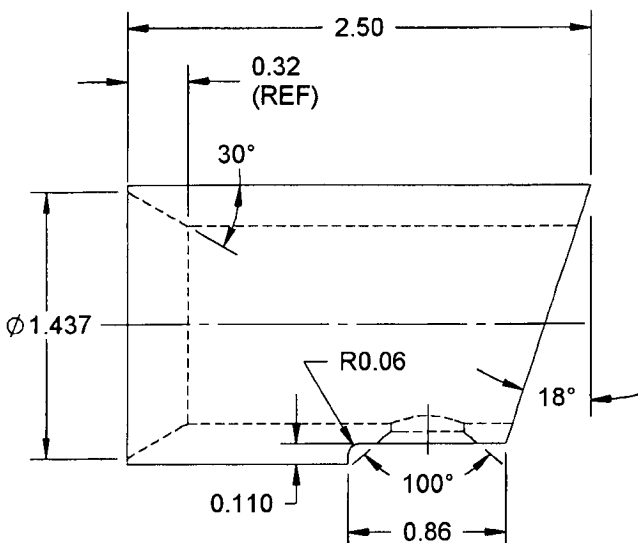
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1



### D3354-9 HANDLE SOCKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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